

Work Order ID 92408

92408

Page 1

October-30-12 12:42:07 PM

Item ID: D3696-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Arm Assembly
 Start Date: 10/29/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 11/09/12 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 12-10-31 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3696	Rev D								
100		0.00							
100	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank 17.600" long								
110		0.00							
110	CONVENTIONAL MILLING MACHINE								
HAAS I	Memo	0.00							
HAAS CNC vertical machine #1	MILL AS PER DWG AND FOLIO FA918								
	DWG REV: <u>D</u>								
	FOLIO REV: <u>AA</u>								
	DEBURR								

Handwritten notes: 12-12-23 (X1) mil'l not pulled not in system yet
 JFC/ 2012-12-29

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	JFC/	2012-12-29		1	0		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	B.A.	12/12/29		1	0		DAS 08 9-89
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				1	26	13-1-3	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3 <i>M122966</i> Memo 1-mask prior to painting as per dwg (see note 8) START TIME: <i>9:20</i> OVEN TEMPERATURE: <i>300°</i> FINISH TIME: <i>9:50</i>	0.00 0.00				<i>1</i>	<i>0</i>	<i>13-1-8</i>	
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<i>5MB</i>		<i>1</i>			
170 *170* Small Fab Small Fab Small Fab	Small Fab Memo 1-Install Helicoil 2-Press Bushing 3-Install Plunger	0.00 0.00				<i>1</i>	<i>0</i>	<i>FF</i> <i>13-01-17</i>	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Doc/Data <input type="checkbox"/>											
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Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00 B-17				1			
190 *190* Packaging Packaging	Identify as per dwg & Stock Location: <u>57271</u> Memo	0.00 0.00							<u>10/30/12</u>
200 *200* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>10/30/12</u> <u>10/30/12</u>

10/30/12
10/30/12
10/30/12

NCR: Yes / No

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Picklist Print

October-30-12 12:42:06 PM

Page 1

Work Order ID: 92408
Parent Item: D3696-041
Parent Item Name: Arm Assembly

Start Date: 10/29/12 Required Date: 11/09/12
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP Rev:A New Issue 08-05-01 JLM Verified By:EC
IPP Rev:B 08-07-22 redesign part (prelim) DD verified by:EC IPP REV:C NOW ON CNC
MILL 10-03-17 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B1.000X1.000 7075 T6 BAR 1.00 x1.00		Purchased	No			100	f	10.3800	1.53	1.5307654			
				124079 x 1.5308									
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT008		10.38							
				114589		1.45							
				122931		8.93							
D3799-1 Oilite Bronze Bushing		Manufactured	No			170	Each	33.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST064		33							
				44915		33							
D3801-3 Hand Retractable Spring Plunger		Manufactured	No			170	Each	6.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST066		6							
				88289		6							
MS21209C8-20 Heli Coil Insert		Purchased	No			170	Each	155.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST304		143							
				108066		143							
				ST305		12							
				120274		12							

DAS 02 12-12-23
2-89

FF 13-01-16

FF 13-01-16

FF 13-01-16

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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DART AEROSPACE LTD		Work Order: 92408
Description: ARM Assembly		Part Number:
Inspection Dwg: D3196-041 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

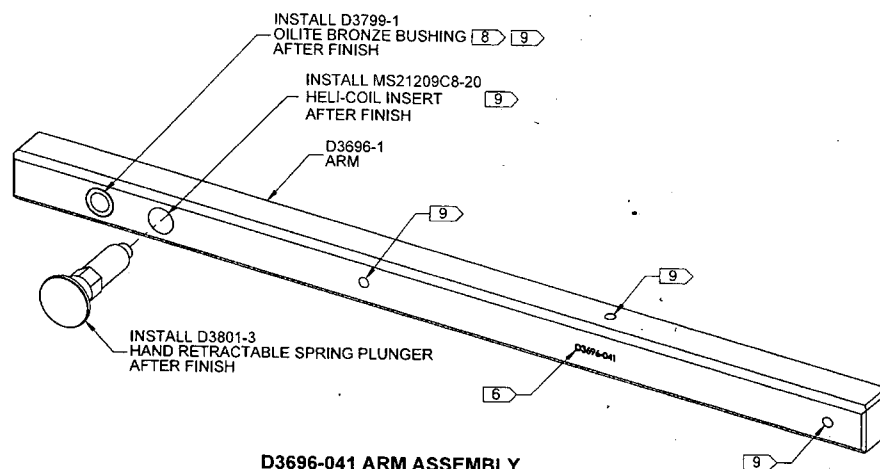
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.566	+0.001/-0.000	0.566	✓			OFC-01
0.516	+0.008/-0.001	0.516	✓			"
0.201	+0.005/-0.001	0.201	✓			"
0.500	+/-0.01	0.500	✓			"
0.300	+/-0.01	0.300	✓			JFC-07
0.06x45°	+/-0.03	0.06	✓			OFC-01
0.500	+/-0.01	0.498	✓			"
1.800	+/-0.01	1.797	✓			"
1.250	+/-0.01	1.248	✓			"
9.500	+/-0.01	9.504	✓			CNC-02
0.750	+/-0.01	0.748	✓			OFC-01
17.50	+/-0.03	17.50	✓			JFC-06
5.500	+/-0.01	5.497	✓			JFC-01
0.495	+/-0.01	0.494	✓			"
0.13	+/-0.03	0.130	✓			31006
0.990	+0.000/-0.010	0.987	✓			OFC-02
						OFC-02

Measured by: OFC/LL	Audited by: D.A. 08	Preliminary Approval:
Date: 2012-12-29.	Date: 12/12/29	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

ITEM	QTY	P/N	DESCRIPTION
1	X	D3696-041	ARM ASSEMBLY
5	1	D3696-1	ARM
6	1	D3799-1	OILITE BRONZE BUSHING
7	1	D3801-3	HAND RETRACTABLE SPRING PLUNGER
11	1	MS21209C8-20	HELI-COIL, SCREW LOCKING (RED)



D3696-041 ARM ASSEMBLY

SHO...
RETURN...
ENGINEERING
UNCONTROLLED
SUBJECT TO A...
WITHOUT NOTICE
WORK ORDER
NO 92408 ML5
12-10-31

RELEASED
2010-05-17
AMP

D3696-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3696-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: 1.68 lbs
- 8) FACE D3799-1 OILITE BRONZE BUSHING FLUSH TO D3696-1 ARM AS REQUIRED ON BOTH SIDES PRIOR TO POWDER COATING
- 9) MASK HOLES AS SHOWN PRIOR TO POWDER COATING

D	REVISED ITEM 5 AS FOLLOWS: *Ø0.201 THRU CBORE Ø0.500 X 0.300 DP NOW 2 PL (ZN C4-2 AND B4-2). REASON: ADDITION OF ALTERNATE ARMREST INSTALLATION D412-761-051 BASED ON FEEDBACK FROM END USERS AT HAI 2010	MB	10.05.06
C	REVISED ITEM 5 AS FOLLOWS: *Ø0.201 THRU CBORE Ø0.500 X 0.300 DP WAS 2 PL (ZN C4-2). REASON: REDESIGNED ARMREST CUSHION BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.06.17
B	P/N D3799-1 WAS BNT-137 (ZN D5-1); P/N D3801-3 WAS PRT-12 (ZN C7-1) - REASON: PURCHASED PARTS NOW PROCURED THROUGH D3799 AND D3801 SPEC CONTROL DRAWINGS; ADDED Ø0.201 HOLE AND CBORE (ZN C5-2 AND D5-2); 17.50 WAS 19.50 (ZN B5-2); 1.000 WAS 0.990 ±0.000-0.010 (ZN C2-2); POCKETS REMOVED REASON: ELIMINATED FWD-AFT ARMREST ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN	1/8		
DRAWN	8		
CHECKED	8		
MFG. APPR.	8		
APPROVED	8		
DE APPR.	8		
DATE	10.05.06		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3696** REV. D
SHEET 1 OF 2
TITLE **ARM ASSEMBLY** SCALE NTS

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Technical drawing of a shaft. The shaft has a central hole with a diameter of $\varnothing 0.201$ THRU and a keyway with a diameter of $\varnothing 0.500 \times 0.300$ DP. The shaft has a total length of 5.500 and a diameter of 0.495 at the right end.

0.13 CHAMFER 4 PL

0.990 $\begin{smallmatrix} +0.000 \\ -0.010 \end{smallmatrix}$

1.000

Technical drawing of a shaft assembly. The drawing shows a shaft with a total length of 17.50. Key features and dimensions include:

- Left End:** REAM TO $\varnothing 0.566^{+0.001}_{-0.000}$. A dimension of 0.500 is shown for the first section.
- First Hole:** $\varnothing 0.516$ THRU TAP HOLE FOR 1/2-13 UNC RED HELI-COIL INSERT. The distance from the left end to the center of this hole is 1.800.
- Second Hole:** The distance between the centers of the first and second holes is 1.250.
- Third Hole:** The distance from the center of the second hole to the center of the third hole is 9.500.
- Fourth Hole:** $\varnothing 0.201$ THRU CBORE $\varnothing 0.500 \times 0.300$ DP 2 PL. The distance from the center of the third hole to the center of this hole is 0.750.
- Right End:** 0.06 X 45° CHAMFER BOTH ENDS.
- Surface Finish:** A surface finish symbol is shown on the shaft surface between the third and fourth holes.

RELEASED
2010-05-17
MJD

D3696-1 NOTES:
 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
 PER AMS-QQ-A-200/11
 REF. DART SPEC. M7075T6B
 2) FINISH: SEE SHEET 1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 1.62 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3696 TITLE ARM ASSEMBLY COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED. IT IS BURNED ON THE EXPRESS COMMAND BUT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIES OR REPRODUCED TO ANY OTHER PERSONS WITHOUT WRITTEN PERMISSION. ALL RIGHTS ARE RESERVED.</small>	REV. D
DRAWN			SHEET 2 OF 2
CHECKED			
MFG. APPR.			
APPROVED			SCALE
DE APPR.			NTS
DATE	10.05.06 -		